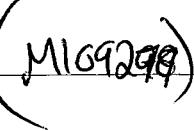
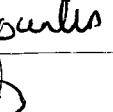
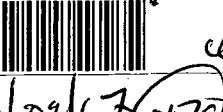


Date: Wednesday, 02/04/2008 3:39:28 PM
User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	X-TUBE EXTRUSION OH-58		
Job Number	38337	Part Number	D6005128		
Estimate Number	10005	Drawing Number	D6005 REV A		
P.O. Number	:	Project Number	N/A		
This Issue	02/04/2008	Type	LANDING GEAR	Drawing Revision	A
Prsht Rev.	NC	Material	:	Due Date	26/09/2008
First Issue	11	Comment	Est Rev:C 04.06.15 Added tolerance to Step 2	Qty:	28
Previous Run	34775	Written By		Um:	Each
Checked & Approved By	JD 08.04.03				
Comment	KJ/JLM				
Additional Product					
Job Number:					
Seq. #:	Machine Or Operation:	Description :			
1.0	PG	PURCHASING			
					
<p>Comment: PURCHASING</p> <p>Issue P/O: <u>6063</u> <u>C 08/04/04</u> </p> <ul style="list-style-type: none"> a) Order as per Dwg D6005 b) Material: 2.750 x 0.375 wall 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube c) Minimum ultimate tensile strength = 77 ksi d) Minimum tensile yield strength = 66 ksi e) Tolerance are per ASTM B210 (see details on Dwg D6005) f) Material certification required 					
2.0	D6005128P	Crosstube material			
					
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 28.0000 Each(s)</p> <p>Crosstube material</p>					
3.0	PACKAGING 1	PACKAGING RESOURCE #1			
					
<p>Comment: PACKAGING RESOURCE #1</p> <p>Receive & Inspect For Transit Damage</p> <p>Ensure material certification is attached</p> <p><u>(M109299)</u> </p> <p><u>88 8/09/15</u> </p> <p><u>x29</u> </p>					
4.0	QC6	DIMENSIONAL CHECK			
					
<p>Comment: DIMENSIONAL CHECK</p> <p>Ensure Material certification comply to Dwg D6005</p> <p><u>50gl017</u> </p> <p><u>+29</u> </p> <p><u>counters</u> </p>					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 3:39:29 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE EXTRUSION OH-58

Job Number: 38337

Part Number: D6005128

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	<i>JKW</i>
6.0	QC3	INSPECT POWDER COAT/ CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION	
7.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>X tube cell</i>	<i>CT 08-09-17-29</i>
8.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	<i>08/09/18</i>

Job Completion



in 08.09.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

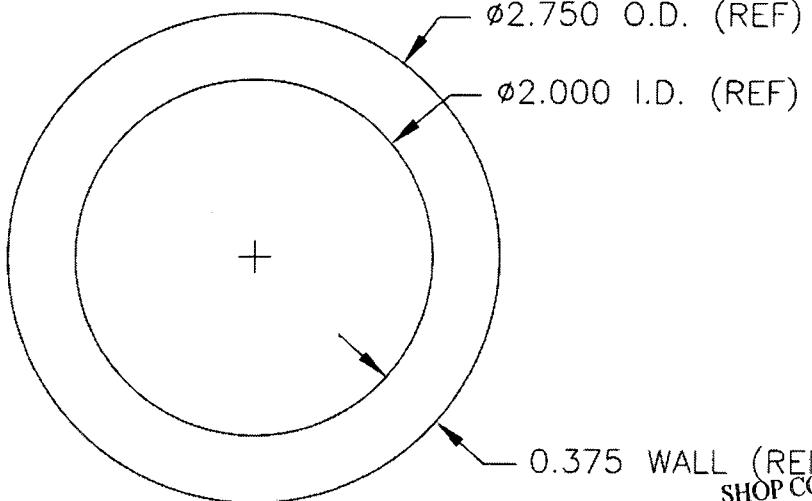
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D6005	SHEET 1 OF 1
DATE	TITLE		
00.11.17	CROSSTUBE MATERIAL		SCALE 1:1
A	00.11.17	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24



NOTES

1) D6005-XXX CROSSTUBE

LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 128" LONG TUBE: D6005-128

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38337

2) MATERIAL: 2.750 OD x 0.375 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.

MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi

MINIMUM YIELD TENSILE STRENGTH = 66 ksi

3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:

OD: ± 0.006 MEAN (± 0.012 INCLUDING OVALITY)

WALL: ± 0.015 MEAN (± 0.038 INCLUDING ECCENTRICITY)

LENGTH: XXX $+0.125/-0.000$

STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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Packinglist ALUnna AG

Customer PO	PO: 00006063
ALUnna ref. no.	29104/6.
Date:	08.14.08

We hereby declare that the wooden packing material are totally free from bark and apparently

free from live plant pests

Boxmarking:

Dart Aerospace PO. 00006063
Made in Germany
Dest, Hawkesbury Ont. Canada

John S. Stolle

Abnahmeprüfzeugnis 3.1 - EN 10204:2004

Inspection Certificate 3.1 - EN 10204:2004 | Certificat de Reception 3.1- EN 10204:2004

Kunde: Client:	Dart Aerospace Ltd.	Zeugnisnummer: 1206/08
	1270 Aberdeen Street K6A1K7 Hawkesbury, ON Canada	<i>Cert No.: / No. du certificat:</i> PO00006063
Produkt: Product / Produit:	Rohre nahtlos gepresst Tubes seamless extruded	Bestellnummer: Order No. / No. de commande
Spezifikation: Specification:	AMS - QQ - A - 200/11E; Spezifikation Dart Aerospace 6005	Auftrag: 29104/6 <i>Our Reference/Notre Reference:</i>
Werkstoff: Alloy/Alliage:	7075	Zustand: T 6511 <i>Temper/État</i>
Abmessung Size / Dimension	2,750 INCH x 2,000 INCH x 0,375 INCH x 128,000 INCH D6005-128 2.750 x 0.375 x 128	
Kennzeichnung Marking/Marquage:	ALUnna - Cert No. 1206/08 - 7075 - T 6511 - Cast No. 1233 - AMS - QQA 200/11 - 2.750" OD X 0.375" Wall - Heat Lot No. 1840 - ALUnna Order Conf. No. 29104/6-1 PO. 00006063	
Lieferung Delivered Material / Matériel délivré:	pcs. 29	lbs 1054
		Country of Manufacture: Germany

1. Chemische Analyse Chemical Analysis / analyse chimique

Charge/ Cast No.	Si min. max.	Fe min. max.	Cu min. max.	Mn min. max.	Mg min. max.	Cr min. max.	Zn min. max.	Ti min. max.	Pb min. max.	Zr min. max.	Bi min. max.	Sn min. max.	Ni min. max.
1233/08	0,121	0,194	1,395	0,055	2,457	0,196	5,775	0,040	0,002	0,0179	0,0001	0,0011	0,0002

Hydrogen content: 0,10 ccm/100 g Al Elements without indication < 0,01 % country of melt manufacturer: Germany

2. Mechanische Eigenschaften Mechanical Properties / Valeurs Mécaniques

Anforderungen Requirements	tensile (Rm) ksi	yield (Rp0,2) ksi	elongation 2" %	elongation A %	Hardness HB	Heat Lot No.
	min. max.	77,0	66,0			
1	86,855	80,185	11,0			1840 - 29 pcs.
2	86,420	79,605	11,0			

RMS outside 25 - max. 20,8 μ "

Ergebnis der Prüfungen: Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

Test results: We confirm that the delivery has been tested and applies to the agreements made on receipt of the order
Resultats: Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande

KrampeR



Certified acc. DIN EN ISO 9001:2000 and DIN EN 9100:2003
valid until 2010-11-11

Cert.- Reg. No.: 001959 QM; 001959 ASH

15.08.2008

Aluminiumwerk Unna AG, Uelzener Weg 36, 59425 Unna, Germany



Abnahmbeauftragter